Q-306R2

SVE BULLETIN

SPECIAL VEHICLE ENGINEERING – BODY BUILDERS ADVISORY SERVICE

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QVM BULLETIN: Q-306R2 DATE: 8 / DEC / 2020

2020 TRANSIT TAILPIPE KIT – CHASSIS CAB AND CUTAWAY

REVISION	UPDATE	REVISION DATE
Q-306R2	Added cutoff date	8 / DEC / 2020
Q-306	INITIAL RELEASE	23 / MAR / 2020

MODEL(S) AFFECTED:
All 2020MY Transit Chassis Cab and Cutaways with Gas Engines build dates up to 25 November 2020.
(Gas Engine Chassis Cab and Cutaway vehicles built on or after November 25, 2020 will ship with a longer tailpipe.)

ISSUE / DESCRIPTION:
The tailpipe extension kit included in the dunnage box for all incomplete vehicles with gas engines may be too short for some intermediate/final stage manufacturers applications. A design change is in process to increase the length of the tailpipe to the same length as 2019MY. This bulletin provides guidance for extending the tailpipe to meet the final stage manufacturers application.

Option 1:
Use service part number CK4Z-5K238B in place of tailpipe kit delivered with the vehicle. Cut to required length based on application.

Option 2:
Add a straight extension on to the pipe delivered with the vehicle which will extend the distance required for the intermediate/final stage manufacturers application.
Pipe Material: Al 409SS – per ASTM A463 Type FSS 409 TIM75), pipe diameter (70mm)
Noted in Figure 1, the end of the straight pipe, which attaches to the tailpipe from the kit, should be swaged to 70.8 +/- 0.3mm ID to a depth of approximately 65 mm. The extension pipe can be secured with a 70 mm or 2 ¾ inch clamp. If welding is the preferred method of attachment use weld wire 409 (409Ti) per AWS A5.22 or option 439 (439Ti) per AWS A5.22

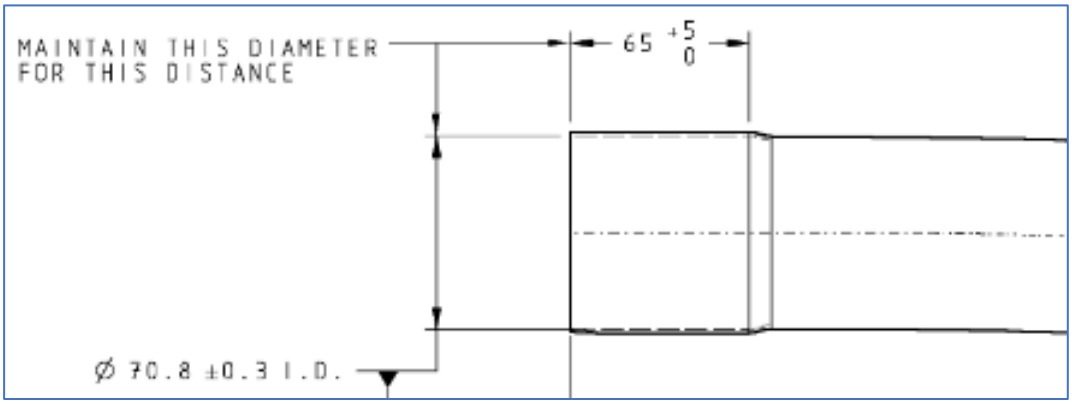

Figure 1: Swage Dimension

Refer to the Body Builder Layout Book for additional guidelines and recommendations. If you have any questions, please contact the Ford Body Builders Advisory Service as shown in the header of this bulletin.